

NO. 119

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay, Elliott  
Joint Welding Procedure tig  
Part number and Job number D550 636 C12 / B322910

TEST WELDS REQUIRED

BASE METAL Aluminum WELDING PROCESS tig  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

|              | Position                    |                             | Vertical Down <input type="checkbox"/> Up <input type="checkbox"/> |                             |
|--------------|-----------------------------|-----------------------------|--|-----------------------------|
| Sheet Groove | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 3G <input type="checkbox"/>  | 4G <input type="checkbox"/> |
| Tube Groove  | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 5G <input type="checkbox"/>  | 6G <input type="checkbox"/> |
| Sheet Fillet | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 3F <input type="checkbox"/>  | 4F <input type="checkbox"/> |
| Tube Fillet  | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 4F <input type="checkbox"/>  | 5F <input type="checkbox"/> |

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07-07-19

Qualifier Ref. D. D. D.



UNDER REVIEW

01-05 CB

OK CB

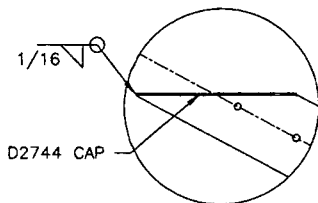
SEE DET. Q

DETAIL G

INSTALL NAS1330S3KB166  
WEARSHOE INSERTS (38 PLACES)  
AFTER FINISH

RELEASED  
06-02-07-11

DETAIL G



D2744 CAP

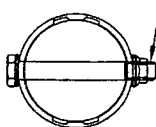
DETAIL K



USE AN3C7A BOLTS  
FOR INSTALLING AFT  
D2648-3 WEARPAD  
(4 PLACES)

AN3C5A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(38 PLACES)

DETAIL P



AN8C35A BOLT (1)  
AN960C816L WASHER (2)  
NAS1515H8L WASHER (2)  
MS21083C8 NUT (1)

INSTALL NAS1330S3KB166  
INSERTS (4 PLACES)  
AFTER FINISH

**D2750-043/-044 ASSEMBLY**  
D2750-043 SHOWN (D2750-044 OPPOSITE)

BOND D2739 WEB INTO D2750-3 (OR D2750-4)  
OUTER TUBE WITH NON-STRUCTURAL  
SIKAFLEX-241 ADHESIVE PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.

SEE DET. P  
SEE DET. N  
D3488-041  
(OR D3488-042)

D2741

BLACK ANTI-SKID

SEE DET. M

NO INSERT

WELDED SPACER  
NOT REQUIRED

SEE DET. K

D2648-3

D2648-3

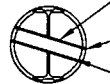
D2656-13

D2746

D2648-3

SECTION H-H

D2743 SPACER (REF)



(TYP)

SECTION J-J



**WELDING INSTRUCTIONS**

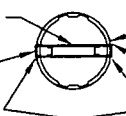
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

SECTION T-T

D3490-1 SPACER

Ø0.500 HOLES ONLY

D3492-041 PLUG ASSEMBLY



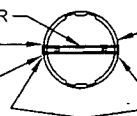
(TYP)

SECTION U-U

D3490-5 SPACER

Ø0.313 HOLES ONLY

D3492-045 PLUG ASSEMBLY

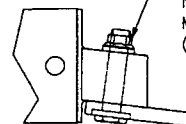


(TYP)

**WELDING INSTRUCTIONS**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-5 SPACER (4 PLACES) INTO Ø0.313 HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS

DETAIL N

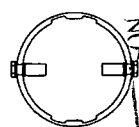


AN8C21A BOLT (1)  
AN960JD816L WASHER (1)  
NAS1515H8L WASHER (1)  
MS21083C8 NUT (1)  
(2 PLACES)

AN3C6A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(4 PLACES)

NOTE: INSTALL WASHER BETWEEN  
SKIDTUBE AND BUSHING

DETAIL Q



AN3C6A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(4 PLACES)

NOTE: INSTALL WASHER BETWEEN  
SKIDTUBE AND BUSHING

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| CHECKED | PH       | APPROVED | PH                    | DRAWING NO.<br>D2750                                     |
| DATE    | 06.01.05 | TITLE    | 350 SKIDTUBE ASSEMBLY | REV. D<br>SHEET 5 OF 5<br>SCALE<br>1:20                  |

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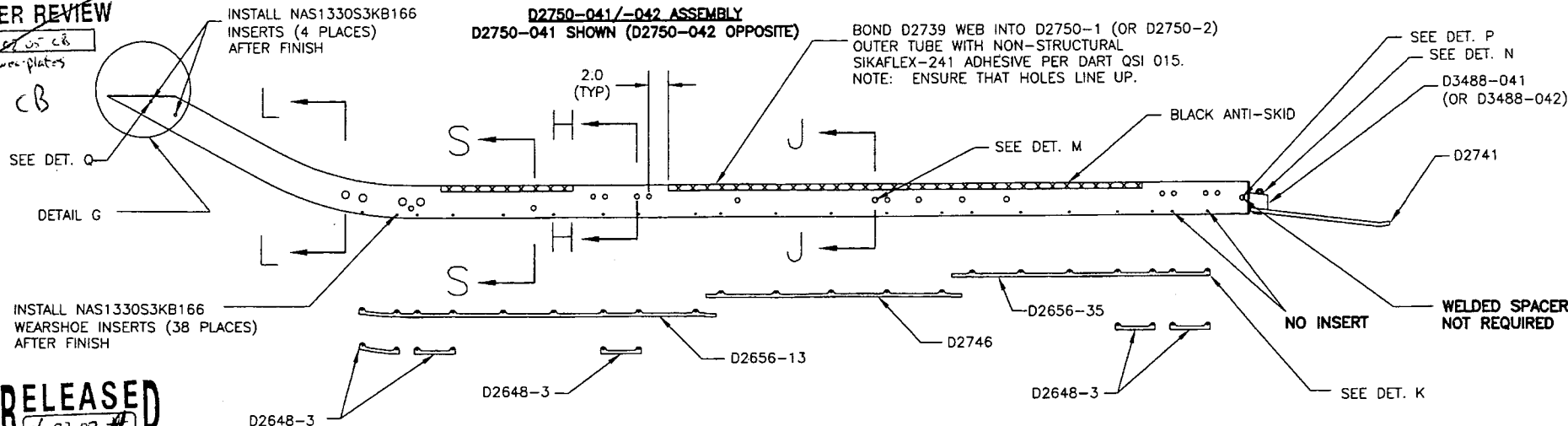
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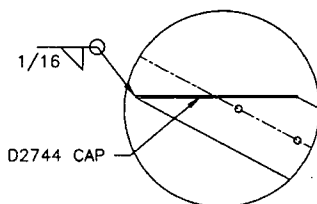
UNDER REVIEW

07.07.05 CB

OK CB



DETAIL G



SECTION H-H



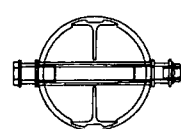
SECTION J-J



WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

DETAIL M



- AN6-44A BOLT (1)  
D2745 BUSHING (2)  
NAS1515H8L WASHER (2)  
MS21043-6 NUT (1)  
(4 PLACES)  
NOTE: INSTALL WASHER BETWEEN SKIDTUBE AND BUSHING

SECTION L-L



Ø0.750 HOLES ONLY

D3492-043 PLUG ASSEMBLY

SECTION S-S



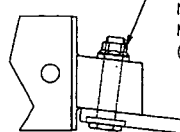
Ø0.500 HOLES ONLY

D3492-041 PLUG ASSEMBLY

WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO Ø0.750 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS

DETAIL N



- AN8C21A BOLT (1)  
AN960JD816L WASHER (1)  
NAS1515H8L WASHER (1)  
MS21083C8 NUT (1)  
(2 PLACES)

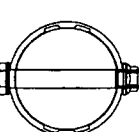
DETAIL K



USE AN3C7A BOLTS FOR INSTALLING AFT D2648-3 WEARPAD (4 PLACES)

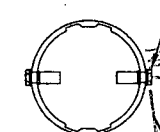
- AN3C5A BOLT (1)  
AN960JD10L WASHER (1)  
NAS1515H3L WASHER (1)  
(38 PLACES)

DETAIL P



- AN8C35A BOLT (1)  
AN960C816L WASHER (2)  
NAS1515H8L WASHER (2)  
MS21083C8 NUT (1)

DETAIL Q



- AN3C6A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H8L WASHER (1)  
(4 PLACES)

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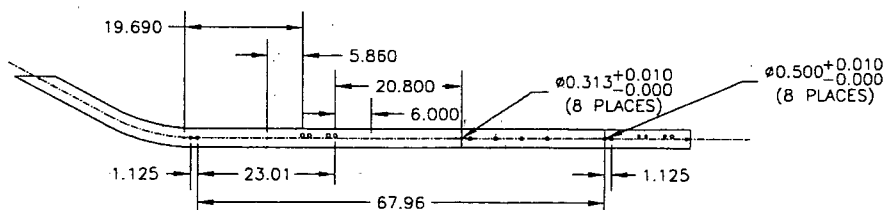
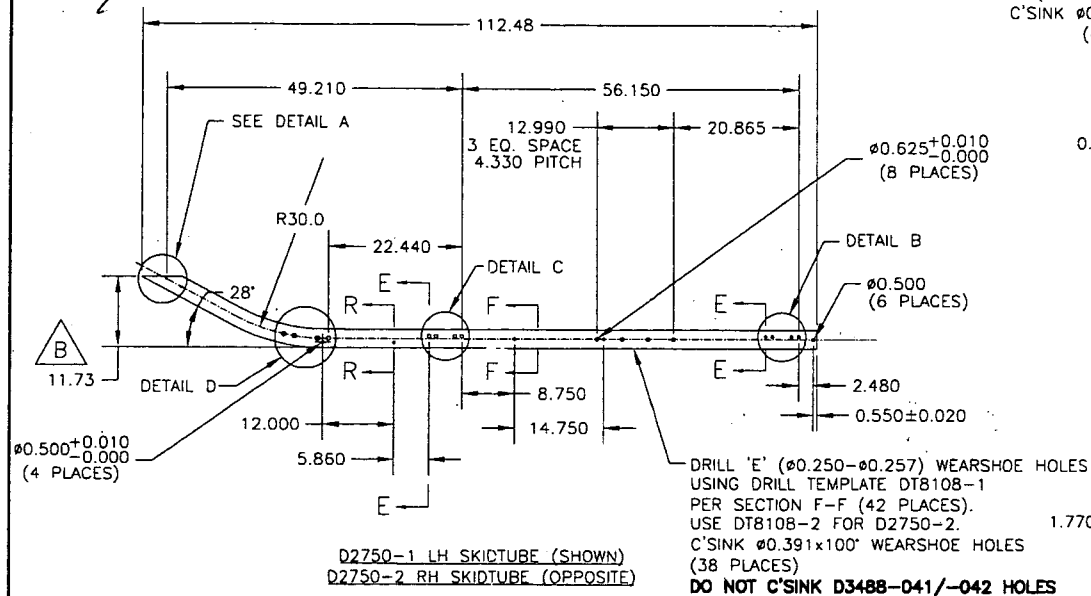
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| DATE    | 06.01.05 | TITLE    | 350 SKIDTUBE ASSEMBLY | REV. 0<br>SHEET 4 OF 5<br>SCALE<br>1:20                  |

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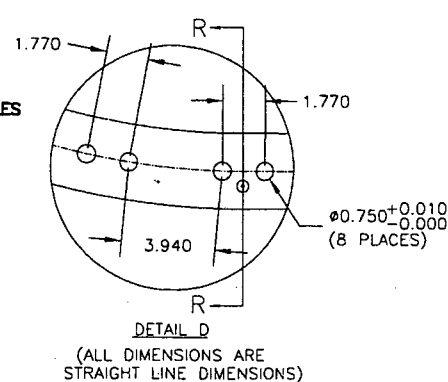
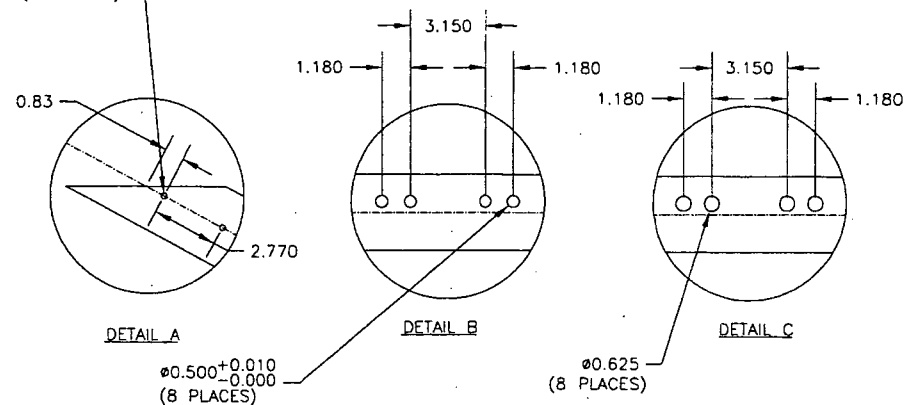
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01-02-07



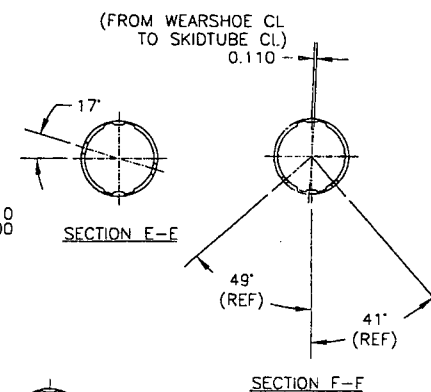
D2750-3 LH SKIDTUBE (SHOWN)  
D2750-4 RH SKIDTUBE (OPPOSITE)  
D2750-3/-4 AND D2750-1/-2 HAVE THE SAME SADDLE AND  
GROUND HANDLING HOLES

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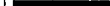
DRILL 'E' ( $\phi 0.250-\phi 0.257$ )  
C'SINK  $\phi 0.291 \times 100$   
(4 PLACES)



(ALL DIMENSIONS ARE  
STRAIGHT LINE DIMENSIONS)



SECTION R-R

|  |  |                                |                |   |                        |
|--|--|--------------------------------|----------------|---|------------------------|
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| DATE<br>06.01.05   |  | TITLE<br>350 SKIDTUBE ASSEMBLY |                |   | SCALE<br>1:20          |



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| DATE<br>06.01.05 |                | TITLE<br>350 SKIDTUBE ASSEMBLY<br>SCALE<br>NTS |                        |

UNDER REVIEW

07.02.05 CB

35 wearplates

OK  
CB

RELEASED  
06.02.07 TH

GENERAL NOTES:

1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES ( $\emptyset 0.250$ -  $\emptyset 0.257$ ) FOR WEARSHOE INSERTS. C'SINK  $\emptyset 0.391 \times 100^\circ$  AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

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**DART****RELEASED**  
06.02.07**UNDER REVIEW**

07.02.05 CB

add gaskets  
change to SS wearplates

|                  |                |   |                        |
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| DATE<br>06.01.05 |                | TITLE<br>350 SKIDTUBE ASSEMBLY<br>SCALE<br>NTS                          |                        |
| A                | 98.04.16       | NEW ISSUE   |                        |
| B                | 98.09.01       | CHANGE MS24694-S293 TO AN8-16A  |                        |
| C                | 98.11.18       | ADD D2750-3/D2750-4<br>INCORPORATE D2738 AND D2740                      |                        |
| D                | 06.01.05       | ADD HOLES AND SPACERS FOR<br>APICAL FLOATS<br>INCORPORATE DEO 9133/9157 |                        |

| Qty<br>-041 | Qty<br>-042 | Qty<br>-043 | Qty<br>-044 | Part Number    | Description           |
|-------------|-------------|-------------|-------------|----------------|-----------------------|
| X           |             |             |             | D2750-041      | SKIDTUBE ASSEMBLY, LH |
|             | X           |             |             | D2750-042      | SKIDTUBE ASSEMBLY, RH |
|             |             | X           |             | D2750-043      | SKIDTUBE ASSEMBLY, LH |
|             |             |             | X           | D2750-044      | SKIDTUBE ASSEMBLY, RH |
| 5           | 5           | 5           | 5           | D2648-3        | WEARPAD               |
| 1           | 1           | 1           | 1           | D2656-13       | WEARSHOE              |
| 1           | 1           | 1           | 1           | D2656-35       | WEARSHOE              |
| 1           | 1           | 1           | 1           | D2746          | WEARSHOE              |
| 1           | 1           | 1           | 1           | D2739          | WEB                   |
| 1           | 1           | 1           | 1           | D2741          | BLADE                 |
| 8           | 8           | 8           | 8           | D2743          | SPACER                |
| 1           | 1           | 1           | 1           | D2744          | CAP                   |
| 8           | 8           | 8           | 8           | D2745          | BUSHING               |
| 1           |             |             |             | D2750-1        | SKIDTUBE WELDMENT, LH |
|             | 1           |             |             | D2750-2        | SKIDTUBE WELDMENT, RH |
|             |             | 1           |             | D2750-3        | SKIDTUBE WELDMENT, LH |
|             |             |             | 1           | D2750-4        | SKIDTUBE WELDMENT, RH |
| 1           |             | 1           |             | D3488-041      | BLADE FITTING, LH     |
|             | 1           |             | 1           | D3488-042      | BLADE FITTING, RH     |
| 4           | 4           | 4           | 4           | D3490-1        | SPACER                |
| 4           | 4           |             |             | D3490-3        | SPACER                |
|             |             | 4           | 4           | D3490-5        | SPACER                |
| 8           | 8           | 8           | 8           | D3492-041      | PLUG ASSEMBLY         |
| 8           | 8           |             |             | D3492-043      | PLUG ASSEMBLY         |
|             |             | 8           | 8           | D3492-045      | PLUG ASSEMBLY         |
| 38          | 38          | 38          | 38          | AN3C5A         | BOLT                  |
| 4           | 4           | 4           | 4           | AN3C6A         | BOLT                  |
| 4           | 4           | 4           | 4           | AN3C7A         | BOLT                  |
| 4           | 4           | 4           | 4           | AN6C44A        | BOLT                  |
| 2           | 2           | 2           | 2           | AN8C21A        | BOLT                  |
| 1           | 1           | 1           | 1           | AN8C35A        | BOLT                  |
| 46          | 46          | 46          | 46          | AN960C10L      | WASHER                |
| 4           | 4           | 4           | 4           | AN960C816L     | WASHER                |
| 4           | 4           | 4           | 4           | MS21043-6      | NUT                   |
| 3           | 3           | 3           | 3           | MS21083C8      | NUT                   |
| 42          | 42          | 42          | 42          | NAS1330S3KB166 | INSERT                |
| 46          | 46          | 46          | 46          | NAS1515H3L     | WASHER                |
| 12          | 12          | 12          | 12          | NAS1515H8L     | WASHER                |

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 32903

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

D34931

WASHER

5



EP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
WASHER B32600 -

49.0

D35321

spacer

5



EP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
spacer B27894 -

50.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



EP 07/08/10 (1)



Comment: INSPECT 100% KITS FOR COMPLETENESS

En 07/08/10 (1)

51.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Package as per PPP D350-636-012

NEVE

EP 07/08/10 (1)

52.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

EP 07/08/10

Job Completion



07/08/10

B32903

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/08/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 32903

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Coat all exposed fasteners with "LPS Procyon"

batch: M104251

*M*

07-08-09

①

41.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*EP 07/08/09*

42.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

43.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: B32583 -

*EP*

44.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M104093 -

*EP*

45.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M104625 -

*EP*

46.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M105107 -

*EP*

47.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M104955 -

*EP*

*EP 07/08/10 ①*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 6/12/2007 3:02:51 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 32903

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M104093

41

36.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M103693

41

37.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M104625

41

38.0

NAS1515H3L

WASHER



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

WASHER

Batch: M104603

46

39.0

NAS1515H8L

WASHER



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

WASHER

Batch: M104922

41

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"

batch: M105085

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M140989

EXP DATE: 08-01

41 07-08-09 Q

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Tuesday, 6/12/2007 3:02:51 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 32903

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D3492043

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B29045 = 2(6x) B30569 = 2(x2) \* HJ

29.0

AN3C5A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Bolt

Batch: M104603 HJ

30.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M103693 HJ

31.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M1103668 HJ

32.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M103964 HJ

33.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M102671 HJ

34.0

AN960C10L

washer



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

washer

Batch: M105143 HJ 07-08-09

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



Date: Tuesday, 6/12/2007 3:02:51 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 32903

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Wearpad

Batch: 1331695

*MS*

22.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: 1332653

*MS*

23.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: 1330554

*MS*

24.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: 1330441

*MS*

25.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: 1331697

*MS*

26.0

D3488042

BLADE FITTING ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: 1331524

*MS*

27.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 1332598

*\**

*MS*

07-08-09

*Q*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 6/12/2007 3:02:51 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 32903

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

9-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750

) R 7730

10-Deburr holes

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/07/30

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/30

16.0

POWDER COATING

POWDER COATING



M105068



(1K)

Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI-005 4.3

M-L 07/08/08  
PRESS WASH BR 07-08-08

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

FL 07/08/09 0

18.0

NAS1330S3KB166

INSERT



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

INSERT

Batch: M105039

251

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

251 07.08-09

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

En 07/08/09 (+0)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 6/12/2007 3:02:51 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 32903

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

D34901

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: *B 32293*

*BE 07-07-19*

11.0

D34903

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: *B 33074*

*BE 07-07-19*

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch: *B 31696*

*BE 07-07-19*

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side)  
as per dwg D2750.

2-Open up holes of Detail D to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail V, Detail C, Detail D and hole size "W" per dwg D2750 (welding instructions on sheet 4)

5-Deburr and blow out all chips from inside of tube

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: *11241732*

exp. date: *8-1-1*

7- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 4)

A/R Aluminum Rod

batch: *1104907*

*BE 07-07-19*

8-Grind welds flush as per Dwg D2750

*7-7-30*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Tuesday, 6/12/2007 3:02:51 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 32903

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description:

as per dwg D2750.

4-Drill pilot holes for Detail B using DT8330

5-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750.

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.250" \*\*\*Make sure that wearplate holes are on bottom of tube\*\*\*\*\*

7-Open up holes of Detail A to 0.250" (total of 2 holes per side)

8- Countersink all fwd wearshoe holes (total of 19 holes per side) DO NOT C'SINK THE LAST AFT HOLES (total of 2 per side for blade fitting) as per dwg D2750.

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004  
A/R Aluminum Rod *m102421 BE 07-06-21*

10-Grind welds flush as per Dwg D2750

11-Countersink Detail A as per dwg D2750.

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch:

*B33062*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ < Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



Date:  
User:Tuesday, 6/12/2007 3:02:51 PM  
Kim Johnston

## Process Sheet

26

|                       |   |                  |                            |
|-----------------------|---|------------------|----------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services   | Drawing Name     | : 350 SKIDTUBE ASSEMBLY RH |
| Job Number            | : 32903   | Part Number      | : D350636012               |
| Estimate Number       | : 10265   | Drawing Number   | : D2750 UNDER REVIEW CB    |
| P.O. Number           | : N/A   | Project Number   | : N/A 07.06.12             |
| This Issue            | : 6/12/2007 S.O. No. : N/A  | Drawing Revision | : D                        |
| Prsht Rev.            | : NC  | Material         | : N/A                      |
| First Issue           | : N/A Type : LANDING GEAR   | Due Date         | : 6/30/2007                |
| Previous Run          | : 32870   | Qty:             | 1 Um: Each                 |
| Written By            | : <u>07.06.12</u>   |                  |                            |
| Checked & Approved By | : <u>07.06.12</u>   |                  |                            |
| Comment               | : Est Rev: I 02.09.25 Rearranged procedure steps KJ<br>Est Rev: J 06-03-29 As per Rev D EC<br>Est Rev: J 06-07.13 As per dsi9343 EC |                  |                            |

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 002

KS 07.06.12

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch #

1 D2600-3-Bent Extrusion (Bent)

D32448 R 7-6-19

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: D29784 BE 07-06-21

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 &amp; DT8863 drilling holes labelled "A" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 &amp; DT8863 and cut

R 7-6-19  
R 7-6-21